

→ ☐

Attorney Docket No

0004.634/P

Total Pages

32

First Named Inventor or Application Identifier

Susumu TSUJIMOTO

(Only for new nonprovisional applications under 37 CFR 1.53(b))

Express Mail Label No

APPLICATION ELEMENTS

See MPEP chapter 600 concerning utility patent application contents.

ADDRESS TO:

Assistant Commissioner of Patents

Box Patent Application

Washington, DC 20231

1. ☒ Fee Transmittal Form
(Submit an original, and a duplicate for fee processing)
2. ☒ Specification [Total Pages 14]
(preferred arrangement set forth below)
- Descriptive title of the invention
 - Cross References to Related Applications
 - Statement Regarding Fed sponsored R&D
 - Reference to Microfiche Appendix
 - Background of the Invention
 - Brief Summary of the Invention
 - Brief Description of the Drawings (if filed)
 - Detailed Description
 - Claim(s)
 - Abstract of the Disclosure
3. ☒ Drawing(s) (35 USC 113) [Total Sheets 8] Formal
4. ☒ Oath or Declaration [Total Pages 2]
- a. ☒ Newly executed (original or copy)
 - b. ☐ Copy from a prior application (37 CFR 1.63(d))
(for continuation/divisional with Box 17 completed)
[Note Box 5 below]
 - 1. ☐ DELETION OF INVENTOR(S)
Signed statement attached deleting inventor(s)
who is/are no longer an inventor in the prior application, see 37 CFR
1.63(d)(2) and 1.33(b)
5. ☐ Incorporation By Reference (useable if Box 4b is checked)
The entire disclosure of the prior application, from which a
copy of the oath or declaration is supplied under Box 4b, is
considered as being part of the disclosure of the
accompanying application and is hereby incorporated by
reference herein.

- 6 ☐ Microfiche Computer Program (*Appendix*)
- 7 Nucleotide and/or Amino Acid Sequence Submission
(*if applicable, all necessary*)
- a ☐ Computer Readable Copy
- b ☐ Paper Copy (identical to computer copy)
- c ☐ Statement verifying identity of above copy

ACCOMPANYING APPLICATION PARTS

- 8 ☒ Assignment Paper (cover sheet & document(s))
9. ☐ 37 CFR 3.73(b) Statement ☐ Power of Attorney
(when there is an assignee)
- 10 ☐ English Translation Document (if applicable)
- 11 ☐ Information Disclosure ☐ Copies of IDS
Statement (IDS)/PTO-1449 Citations
12. ☐ Preliminary Amendment
13. ☒ Return Receipt Postcard (MPEP 503)
(should be specifically itemized)
14. ☐ Small Entity ☐ Statement filed in prior application,
Statement(s) Status still proper and desired
- 15 ☐ Certified Copy of Priority Document(s)
(if foreign priority is claimed)
- 16 ☒ Other CLAIM FOR PRIORITY, and
CHANGE OF FIRM NAME

17. If a CONTINUING APPLICATION, check appropriate box and supply the requisite information.

☐ Continuation ☐ Divisional ☐ Continuation-in-part (CIP) of prior application No. /

18 CORRESPONDENCE ADDRESS

☐ Customer Number or Bar Code Label 002779 and/or ☐ Correspondence address below
(insert Customer No. or Attach bar code label here)

NAME _____

Michael Q. White

Michael D White

Registration No

32,795

Date May 7, 1998

ADDRESS

BLANK ROME COMISKY & McCAULEY LLP
Wigman, Cohen, Leitner & Myers IP Group

900 17TH STREET, N W , SUITE 1000

CITY

WASHINGTON

STATE

DC

ZIP CODE

20006

COUNTRY

US

TELEPHONE

(202) 463-7700

FACSIMILE

(202) 463-6915

Under the Paperwork Reduction Act of 1995, no persons are required to respond to a collection of information unless it displays a valid OMB control number.

FEE TRANSMITTAL

Patent fees are subject to annual revision on October 1.

These are the fees effective October 1, 1997.

Small Entity payments must be supported by a small entity statement, otherwise large entity fees must be paid. See Forms PTO/SB/09-12.

TOTAL AMOUNT OF PAYMENT (\$ 830.00

Complete if Known

Application Number	
Filing Date	May 7, 1998
First Named Inventor	Susumu TSUJIMOTO
Examiner Name	
Group / Art Unit	
Attorney Docket No.	0004.634/P

METHOD OF PAYMENT (check one)

1. ☒ The Commissioner is hereby authorized to charge indicated fees and credit any over payments to:

Deposit Account Number	23-2185
Deposit Account Name	

- ☒ Charge Any Additional Fee Required Under 37 CFR 1.16 and 1.17 ☐ Charge the Issue Fee Set in 37 CFR 1.18 at the Mailing of the Notice of Allowance

2. ☒ Payment Enclosed:

☒ Check ☐ Money Order ☐ Other

FEE CALCULATION**1. BASIC FILING FEE**

Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description	Fee Paid
101 790	201 395	Utility filing fee	790.00
106 330	206 165	Design filing fee	
107 540	207 270	Plant filing fee	
108 790	208 395	Reissue filing fee	
114 150	214 75	Provisional filing fee	

SUBTOTAL (1) (\$ 790.00

2. EXTRA CLAIM FEES

		Extra Claims		Fee from below	Fee Paid
Total Claims	7	-20**	= 0	X 0	= 0
Independent Claims	2	-3**	= 0	X 0	= 0
Multiple Dependent				0	= 0

**or number previously paid, if greater; For Reissues, see below

Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description	Fee Paid
103 22	203 11	Claims in excess of 20	
102 82	202 41	Independent claims in excess of 3	
104 270	204 135	Multiple dependent claim, if not paid	
109 82	209 41	** Reissue independent claims over original patent	
110 22	210 11	** Reissue claims in excess of 20 and over original patent	

SUBTOTAL (2) (\$ -0-

FEE CALCULATION (continued)**3. ADDITIONAL FEES**

Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description	Fee Paid
105 130	205 65	Surcharge - late filing fee or oath	
127 50	227 25	Surcharge - late provisional filing fee or cover sheet	
139 130	139 130	Non-English specification	
147 2 520	147 2,520	For filing a request for reexamination	
112 920*	112 920*	Requesting publication of SIR prior to Examiner action	
113 1,840*	113 1,840*	Requesting publication of SIR after Examiner action	
115 110	215 55	Extension for reply within first month	
116 400	216 200	Extension for reply within second month	
117 950	217 475	Extension for reply within third month	
118 1,510	218 755	Extension for reply within fourth month	
128 2,060	228 1,030	Extension for reply within fifth month	
119 310	219 155	Notice of Appeal	
120 310	220 155	Filing a brief in support of an appeal	
121 270	221 135	Request for oral hearing	
138 1,510	138 1,510	Petition to institute a public use proceeding	
140 110	240 55	Petition to revive - unavoidable	
141 1,320	241 660	Petition to revive - unintentional	
142 1,320	242 660	Utility issue fee (or reissue)	
143 450	243 225	Design issue fee	
144 670	244 335	Plant issue fee	
122 130	122 130	Petitions to the Commissioner	
123 50	123 50	Petitions related to provisional applications	
126 240	126 240	Submission of Information Disclosure Stmt	
581 40	581 40	Recording each patent assignment per property (times number of properties)	40.00
146 790	246 395	Filing a submission after final rejection (37 CFR 1.129(a))	
149 790	249 395	For each additional invention to be examined (37 CFR 1.129(b))	
Other fee (specify)			
Other fee (specify)			
* Reduced by Basic Filing Fee Paid		SUBTOTAL (3)	(\$ 40.00

SUBMITTED BY

Typed or Printed Name Michael D. White

Signature Michael D. White

Date 5/7/98

Complete (if applicable)

Reg. Number 32,795

Deposit Account User ID

Burden Hour Statement: This form is estimated to take 0.2 hours to complete. Time will vary depending upon the needs of the individual case. Any comments on the amount of time you are required to complete this form should be sent to the Chief Information Officer, Patent and Trademark Office, Washington, DC 20231. DO NOT SEND FEES OR COMPLETED FORMS TO THIS ADDRESS. SEND TO: Assistant Commissioner for Patents, Washington, DC 20231.

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Patent Application of:)
)
Susumu TSUJIMOTO) Attn: Application Branch
)
Serial No. Not Yet Assigned) Examiner:
)
Filed: Concurrently Herewith) Atty. Docket No.: 0004.634/P
) VMW:MDW:jm
For: BAND SAW BLADE)
) May 7, 1998

CHANGE OF FIRM NAME

Hon. Commissioner of Patents and Trademarks
Washington, D.C. 20231

Sir:

Notice is hereby given that the name of the law firm representing Applicant in the above-identified application has been changed. The address has not changed. The new firm name (and correspondence address) is:

Blank Rome Comisky & McCauley LLP
Wigman, Cohen, Leitner & Myers Intellectual Property Group
The Farragut Building - Suite 1000
900 17th Street, N.W.
Washington, D.C. 20006

Please direct all correspondence to Victor M. Wigman at the above address.

Respectfully submitted,

Susumu TSUJIMOTO

By Michael D. White
Michael D. White
Reg. No. 32,795

BLANK ROME COMISKY & McCAULEY LLP
Wigman, Cohen, Leitner & Myers IP Group
The Farragut Building
900 17th Street, N.W., Suite 1000
Washington, D.C. 20006
Tel.: (202) 463-7700
Fax: (202) 463-6915

APPLICATION FOR UNITED STATES LETTERS PATENT

TITLE: BAND SAW BLADE

INVENTORS: Susumu TSUJIMOTO

ASSIGNEE: AMADA COMPANY, LIMITED

BLANK ROME COMISKY & McCAULEY LLP
Wigman, Cohen, Leitner & Myers IP Group
The Farragut Building
Suite 1000 - 10th Floor
900 17th Street, N.W.
Washington, D.C. 20006
(202) 463-7700

Docket No. 0004.634/P

SPECIFICATION
BAND SAW BLADE

BACKGROUND OF THE INVENTION

5 **Field of the Invention**

The present invention relates to a band saw blade used for a band sawing machine such as a horizontal band sawing machine and a vertical band sawing machine.

Description of the Related Arts

10 Conventionally, there is a band saw blade with a variable pitch in which a pitch of a saw tooth is different. The saw tooth of the band saw blade is constituted by a left-set tooth and a right-set tooth.

 However, since the pitch of the saw tooth is different,
15 it is complex to adjust a setting amount in each of the set teeth, and it is hard to accurately form the setting amount.

SUMMARY OF THE INVENTION

 The present invention has been achieved with such points
20 in mind.

 It therefore is an object of the present invention to provide a band saw blade which can make it simple to adjust a setting amount in each of set teeth and can adjust a plurality of set teeth at the same time.

25 Another object of the present invention is to provide a band saw blade which can accurately form the setting amount of the set tooth as substantially same amount as previously desired, and can intend to increase a life of the band saw blade and to improve a roughness of a cutting surface.

30 To achieve the object, according to a first aspect of the present invention, there is provided a band saw blade comprising: a plurality of set teeth, the plurality of set teeth being formed in a variable pitch, wherein a bending lengths of each of the set teeth at a setting and bending position or at
35 a bendingly setting position are substantially equal to each other.

By making the bending length of each of the set teeth at the bending position substantially the same length, it is possible to make a bending resistance at a time of form a setting substantially constant, and a spring back amount of each of the set teeth after the set tooth is bent can be substantially constant. Further, a plurality of set teeth can be adjusted and pressed along the setting and bending position at the same time and the setting amount can be simply adjusted.

According to a second aspect of the present invention, there is provided a band saw blade comprising: a plurality of set teeth, the plurality of set teeth being formed in a variable pitch, wherein a bending length of each of the set teeth at a setting and bending position is substantially the same length; and setting amounts in right and left directions of each of the set teeth are substantially equal to each other.

In accordance with the structure mentioned above, even in the structure comprising a plurality of setting teeth having a different setting amount in the right and left directions, the setting teeth having the setting amounts in the right and left directions equal to each other are accurately set to the right and left directions with respect to each other, as substantially same amount as previously desired.

According to a third aspect of the present invention, as it depends from the first or the second aspect, each of the set teeth has substantially the same shape in a portion from a setting and bending position line or from a bending setting position line to a tip.

By making the shape of each of the set teeth in the portion from the setting and bending position line or from the bending setting position line to the tip substantially the same shape, a deforming amount of the tip becomes substantially the same as that of each of the set teeth, so that the setting amount of each of the set teeth is made uniform.

Accordingly, as well as the spring back amount of each of the set teeth is substantially equal to each other, the set tooth can be set and formed in a more even and accurate manner.

Further, abrasions of each of the set teeth in the band saw blade can be made even, the life of the band saw blade can be increased and the roughness of the cutting surface on a work to be cut can be improved.

5 According to a fourth aspect of the present invention, as it depends from the first, the second or the third aspect, the setting and bending position or the bendingly setting position in each of the set teeth is positioned on a same straight line.

10 Accordingly, at a time of setting and bending each of the set teeth, the setting and bending can be easily performed by making a clamp position by a clamp vice for clamping the band saw blade as a reference position or a standard position.

15 As mentioned above, in any of the aspects, the setting and forming can be easily and accurately performed, so that an improvement in the roughness of the cutting surface on the work to be cut and an increase of the life of the band saw blade or band sawing machine which are responsible to the actual need by users in the market can be realized.

20

BRIEF DESCRIPTION OF THE ACCOMPANYING DRAWINGS

25 The above and further objects and novel features of the present invention will more fully appear from the following detailed description when the same is read in conjunction with the accompanying drawings, in which:

 Figs. 1A and 1B are schematic views which show a band saw blade in accordance with an embodiment of the present invention;

30 Figs. 2A and 2B are schematic views which show a band saw blade in accordance with a second embodiment of the present invention;

 Figs. 3A and 3B are schematic views which show a band saw blade in accordance with a third embodiment of the present invention;

35 Figs. 4A and 4B are schematic views which show a band saw blade in accordance with a fourth embodiment of the present invention;

Figs. 5A and 5B are schematic views which show a band saw blade in accordance with a fifth embodiment of the present invention;

5 Figs. 6A and 6B are schematic views which show a band saw blade in accordance with a sixth embodiment of the present invention;

Figs. 7A and 7B are schematic views which show a structure of the band saw blade and a set pressing element; and

10 Figs. 8A, 8B and 8C are schematic views which show a setting process in the band saw blade.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

15 There will be detailed below the preferred embodiments of the present invention with reference to the accompanying drawings. Like members are designated by like reference characters.

20 In accordance with the present invention, a band saw blade BS used for a band sawing machine is structured in a variable pitch, for example, having five teeth a to e disposed in such a manner as to have five kinds of different pitches P1 to P5 as one group, as shown in Figs. 7A and 7B. Further, the a tooth is constituted by an unset tooth having no set, the b and d teeth are constituted by right-set teeth and the c and e teeth are constituted by left-set teeth.

25 Each of the set teeth b to e shown in Fig. 7A is pressed by pressing elements f to i so as to be performed a setting process. Further, as shown in Fig. 7B, an j-j line indicates a setting and bending position (a position of a clamp vice for clamping the band saw blade BS at a time of performing a setting),
30 however, the respective bending lengths of the set teeth b to e are set to be L1 to L4 and they are all different in length ($L1 \neq L2 \neq L3 \neq L4$).

Next, a basic operation for performing a setting process will be described below with reference to Figs. 8A, 8B and 8C.
35 Figs. 8A, 8B and 8C show a state of forming a saw tooth q to a setting amount n at a bending position j-j line by means of

a pressing element P. The j-j line corresponds to a position on an upper surface of right and left clamp vices B. Accordingly, Fig. 8A shows a state in which the pressing element P is in contact with the saw tooth q, Fig. 8B shows a state in which the pressing element P reaches a stroke end, and Fig. 8C shows a state in which the pressing element P is apart from the saw tooth q and returns to the original position after being performed the setting process.

As is understood from Figs. 8A, 8B and 8C, a relation $r > n$ is always generated between a pressing amount r by which the pressing element P presses the saw tooth q and a setting amount n. This phenomenon is caused by the following reasons:

(1) In comparison that the pressing element P is linearly moved, the saw tooth q is inclined in such a manner as to rotate.

(2) A spring back m is generated.

(3) A deformation ($k_1 - k_2$) in a tip is generated.

Among them, with respect to the item (1), it is a constant amount even when the tip shape is different, however, with respect to the items (2) and (3), when the tip shape (particularly, the shape from the bending position j-j line of the set tooth to the tip) is different, there is generated a difference in the value of the spring back m and the deformation amount ($k_1 - k_2$), and particularly the bending length on the bending position j-j line gives a great influence.

Accordingly, in the band saw blade BS having a variable pitch, since the tip shape of the set teeth b to e among the tooth type group is not constant and particularly the bending lengths L1 to L4 on the bending position j-j line are not constant, there is generated a difference in the value of the items (2) and (3) mentioned above, so that in order to make the setting amount n of each of the teeth b to e constant, it is necessary to adjust the projecting amount of the pressing element P independently in each of the teeth b to e.

Further, even in the case of adjusting such that each of the set teeth b to e becomes the same setting amount n, the deformation amount of the tip is different in each of the teeth

due to the difference in the tooth shape. Accordingly, an amount of the unevenness in each of the tips is dispersed.

In this case, the need by users in the market requests a band saw blade having a further accuracy, so that a band saw
5 blade having a tip abraded and finished is appeared.

In order to produce a band saw blade having a further super accuracy for the future, it is indispensable to make a setting process highly accurate and stable, and it is an urgent necessity to establish a tooth design of a band saw blade and
10 a method of producing the same with taking a plastic deformation at a time of performing a setting process into consideration.

Another embodiment of the present invention modified by taking the condition mentioned above into consideration will be described below in detail.

15 With reference to Figs. 1A and 1B, a band saw blade BS with a variable pitch comprising seven teeth disposed at seven kinds of different pitches P1 to P7 as one group is shown. In this case, among the seven teeth 1, 3, 5, 7, 9, 11 and 13, the tooth 1 is an unset tooth, the teeth 3, 7 and 11 are left-set
20 teeth and the teeth 5, 9 and 13 are right-set teeth. Further, all of positive rake angles and radial relief backs of the respective teeth 1 to 13 are constant, and further it is set that a tooth bottom R is constant in all the teeth and a gullet depth D is constant.

25 The band saw blade BS is produced in such a manner that a bending resistance at a time of performing a setting and bending in each of the set teeth becomes substantially equal to each other, the spring back amount of each of the set teeth after performing a setting and bending becomes substantially
30 equal to each other, and the deformation amount of each of the set teeth after setting and bending becomes substantially equal to each other.

Accordingly, as shown in Fig. 1B, the j-j line shows the setting and bending position, and all of the bending length L
35 of each of the set teeth 3 to 13 are constant. Further, the shape from the setting and bending position j-j line to the tip

S of each of the set teeth 3 to 13 is constant in all the teeth. In this case, the setting and bending position may be closer to the tip S than the j-j line, and may be closer to the tooth bottom.

5 Accordingly, by making the bending length L of the setting and bending position j-j line in each of the set teeth 3 to 13 is substantially equal to each other, the bending resistance of each of the set teeth at a time of performing the setting process becomes substantially equal to each other and the spring
10 back amount after setting and bending becomes substantially equal to each other. Further, a plurality of set teeth 3 to 13 can be pressed along the setting and bending position j-j line at the same time, and the setting amount can be simply adjusted.

15 In this case, when the bending length L within the one group of the teeth type is actually measured and the average value is set to be LA, it is desirable that the dispersion in each of the teeth is within $\pm 10\%$.

Further, by making the shape from the setting and bending
20 position j-j line to the tip S in each of the set teeth 3 to 13 substantially equal to each other, the deformation amount of the tip S after setting and bending becomes equal to each other in each of the set teeth 3 to 13, so that the unevenness in each of the set teeth 3 to 13 can be made even. Accordingly,
25 the spring back amount and the deformation amount of each of the set teeth are substantially equal to each other, respectively, a setting process at a more even and accurate manner can be performed and the abrasion in each of the teeth in the band saw blade BS can be made even, so that the life can
30 be increased and the roughness of the cutting surface can be improved.

A second embodiment is shown in Figs. 2A and 2B, and a band saw blade BS with a variable pitch comprising seven teeth disposed at seven kinds of different pitches P1 to P7 as one
35 group is shown. Among the seven teeth 1, 3, 5, 7, 9, 11 and 13, the tooth 1 is an unset tooth, the teeth 3, 7 and 11 are

left-set teeth and the teeth 5, 9 and 13 are right-set teeth. Further, all of positive rake angles and radial relief backs of the respective teeth 1 to 13 are constant, and bending lengths L of each of the teeth 3 to 13 on the setting and bending position j-j line are all set to be constant. Further, the teeth bottoms R1 to R7 respectively have a different curvature, and it is set that a contact point of the tooth bottom R is not closer to the tip S than a crossing point X1 between the front surface T and the j-j line and a crossing point X2 between the surface of relief and the j-j line. Accordingly, all of the tip end shapes from the j-j line to the tip S are constant. In this case, the setting and bending position may be set to be closer to the tip S than the j-j line.

In this case, when the bending length L within the one group of the teeth type is actually measured and the average value is set to be LA, it is desirable that the dispersion in each of the teeth is within $\pm 10\%$.

Accordingly, in the embodiment shown in Figs. 2A and 2B, the same operation and effect as those of the saw blade embodied in Figs. 1A and 1B mentioned above can be obtained.

A third embodiment is shown in Figs. 3A and 3B, and a band saw blade BS with a variable pitch comprising seven teeth disposed at seven kinds of different pitches P1 to P7 as one group is shown. Among the seven teeth 1, 3, 5, 7, 9, 11 and 13, the tooth 1 is an unset tooth, the teeth 3, 7 and 11 are left-set teeth and the teeth 5, 9 and 13 are right-set teeth. The tip end shapes of the set teeth 3 and 5 are formed to be equal to each other, and the tip end shapes of the set teeth 7, 9, 11 and 13 are formed to be equal to each other. Then, the radial relief backs α_6 and α_5 of the tip front end portion in the right and left set teeth 3 and 5 following to the unset tooth 1 are set to be smaller than the radial relief backs α_4 , α_3 , α_2 and α_1 of the other set teeth 7, 9, 11 and 13. Further, since the setting and bending position j-j line is not in contact with the tooth bottom R portion of any of the set teeth 3 to 13, the point X1 is disposed at a position of the line having

the same bending length L as that of the set teeth 7, 9, 11 and 13 on the j-j line closer to the crossing point X2 between the front surface line and the j-j line in the tooth 3, the second radial relief back c is provided from the point X1 as shown in Fig. 3B and the tooth 5 is processed by the same method, thereby easily setting the setting and bending lengths L of all of the set teeth 3 to 13 substantially equal to each other.

In this case, when the bending length L within the one group of the teeth type is actually measured and the average value is set to be LA, it is desirable that the dispersion in each of the teeth is within $\pm 10\%$.

Accordingly, in the band saw blade BS shown in Figs. 4A and 4B, even in the case that the shape from the setting and bending position j-j line to the tip of each of the teeth is different by providing the second radial relief back C in the teeth 3 and 5, the bending length L in each of the teeth is substantially equal to each other and the spring back amount after setting and bending becomes substantially equal to each other, so that the same operation and effect as those of the band saw blade BS shown in Fig. 1 can be obtained.

A fourth embodiment is shown in Figs. 4A and 4B, and a band saw blade BS with a variable pitch comprising seven teeth disposed at seven kinds of different pitches P1 to P7 as one group is shown. Among the seven teeth 1, 3, 5, 7, 9, 11 and 13, the tooth 1 is an unset tooth, the teeth 3, 7 and 11 are left-set teeth and the teeth 5, 9 and 13 are right-set teeth. The tip end shapes of the set teeth 3 and 5 are formed to be equal to each other, and the tip end shapes of the set teeth 7, 9, 11 and 13 are formed to be equal to each other. The positive rake angles θ_6 and θ_5 of the right and left set teeth 3 and 5 following to the unset tooth 1 are set to be smaller than the positive rake angles θ_4 , θ_3 , θ_2 and θ_1 of the other set teeth 7, 9, 11 and 13.

Further, since the setting and bending position j-j line is not in contact with the tooth bottom R portion of any of the set teeth 3 to 13, the point X1 is disposed at a position of

the line having the same bending length L as that of the set teeth 7, 9 and 11 on the j-j line closer to the crossing point X2 between the front surface line and the j-j line in the tooth 3, the second radial relief back c is provided from the point X1 as shown in Fig. 3B and the tooth 5 is processed by the same method, thereby easily setting the setting and bending lengths L of all of the set teeth 3 to 13 substantially equal to each other.

In this case, when the bending length L within the one group of the teeth type is actually measured and the average value is set to be LA, it is desirable that the dispersion in each of the teeth is within $\pm 10\%$.

Accordingly, in the band saw blade BS shown in Figs. 4A and 4B, even in the case that the shape from the setting and bending position j-j line to the tip of each of the teeth is different by providing the second radial relief back C in the teeth 3 and 5, the bending length L in each of the teeth is substantially equal to each other and the spring back amount after setting and bending becomes substantially equal to each other, so that the same operation and effect as those of the band saw blade BS shown in Fig. 1 can be obtained.

A fifth embodiment is shown in Figs. 5A and 5B, and a band saw blade BS with a variable pitch comprising five teeth disposed at five kinds of different pitches P1 to P5 as one group is shown. Among the five teeth 15, 17, 19, 21 and 23, the tooth 15 is an unset tooth, the teeth 17 and 21 are right-set teeth and the teeth 19 and 23 are left-set teeth.

All of the unset tooth 15, the right-set teeth 17 and 21 and the left-set teeth 19 and 23 have the same radial relief back and the same positive rake angle, however, the curvature of the tooth bottoms R1 to R5 are different in all the teeth. Then, since the setting and bending position j-j line is in contact with the tooth bottom R close to the front surface T, the point X1 is disposed at a position of the line having the length L on the j-j line closer to the crossing point X2 between the surface of relief line and the j-j line so as to be in contact

with the front surface T line and the surface of relief U line and the tooth bottom R is formed in such a manner as to pass through the point X1, thereby easily setting the setting and bending lengths L of all of the set teeth 17 to 23 substantially equal to each other.

In this case, when the bending length L within the one group of the teeth type is actually measured and the average value is set to be LA, it is desirable that the dispersion in each of the teeth is within $\pm 10\%$.

Accordingly, in the band saw blade BS shown in Figs. 5A and 5B, the same operation and effect as those of the band saw blade BS shown in Fig. 1 can be obtained.

A sixth embodiment is shown in Figs. 6A and 6B, and a band saw blade BS with a variable pitch comprising eight teeth disposed at eight kinds of different pitches P1 to P8 as one group is shown. In the band saw blade BS, the teeth 25 and 33 are unset teeth, the teeth 27, 31 and 37 are left-set teeth and the teeth 29, 35 and 39 are right-set teeth.

Then, the left-set tooth 27 and the right-set tooth 39 are formed in such a manner that the setting amount is small and the shape of the portion closer to the tip end than the setting and bending position j-j line is equal to each other, and the bending length L1 at the setting and bending position is set to be equal to each other. The setting amount of the right and left set teeth 29, 31, 35 and 37 is larger than the setting amount of the right and left teeth 27 and 39, the shape of the portion closer to the tip end than the setting and bending position j-j line in each of the set teeth 29, 31, 35 and 37 is set to be equal to each other and the bending length L2 at the setting and bending position is set to be equal to each other.

Accordingly, in the embodiment, the tip end shape and the setting and bending length in each of the set teeth having the equal setting amount in the right and left directions are set to be equal to each other. Accordingly, even in the case of the structure having a plurality of set teeth having the different right and left setting amounts, since the right and

left set teeth having the equal setting amount in the right and left directions have the tip end shape and the setting and bending length equal to each other, they can be accurately set to the right and left directions in such a manner as to be equal to each other.

In this case, when the bending length L within the one group of the teeth type is actually measured and the average value is set to be LA , it is desirable that the dispersion in each of the teeth is within $\pm 10\%$.

In this case, in the band saw blade BS shown in Figs. 6A and 6B, the tip end shapes of all of the teeth may be equal to each other, the setting and bending length may be equal to each other, and the setting amount of all of the set teeth may be equal to each other.

In the embodiments shown in Figs. 1 to 6 mentioned above, a direction indicated by an arrow v shows a moving direction of the band saw blade BS and a direction indicated by an arrow w shows a cutting direction against a work (not shown).

Further, in the embodiments shown in Figs. 1 to 6, the embodiments are shown with respect to the band saw blade with the variable pitch comprising five teeth, seven teeth or eight teeth for constituting one group, however, the number of the teeth within the one group and the set pattern can be optionally set.

In this case, the present invention is not limited to the embodiments mentioned above, and can be realized by the other aspects by suitably modifying. For example, the setting and bending position in each of the set teeth may be disposed on different levels in place of being disposed on one straight line.

While preferred embodiments of the present invention have been described using specific terms, such description is for illustrative purposes, and it is to be understood that changes and variations may be made without departing from the spirit or scope of the following claims.

WHAT IS CLAIMED IS:

1. A band saw blade, comprising:

a plurality of set teeth, the plurality of set teeth being formed in a variable pitch, wherein

5 a bending lengths of each of the set teeth at a setting and bending position are substantially equal to each other.

2. A band saw blade, comprising:

10 a plurality of set teeth, the plurality of set teeth being formed in a variable pitch, wherein

a bending length of each of the set teeth at a setting and bending position is substantially the same length; and

setting amounts in right and left directions of each of the set teeth are substantially equal to each other.

15 3. The band saw blade according to claim 1, wherein

each of the set teeth has substantially the same shape in a portion from the setting and bending position line to a tip.

20 4. The band saw blade according to claim 2, wherein

each of the set teeth has substantially the same shape in a portion from the setting and bending position line to a tip.

25 5. The band saw blade according to claim 1, wherein

the setting and bending position in each of the set teeth is positioned on a same straight line.

30 6. The band saw blade according to claim 2, wherein

the setting and bending position in each of the set teeth is positioned on a same straight line.

35 7. The band saw blade according to claim 3, wherein

the setting and bending position in each of the set teeth is positioned on a same straight line.

ABSTRACT OF THE DISCLOSURE

A band saw blade includes a plurality of set teeth which are formed in a variable pitch. In that construction, a bending lengths of each of the set teeth at a setting and bending position
5 or at a bendingly setting position are substantially equal to each other.

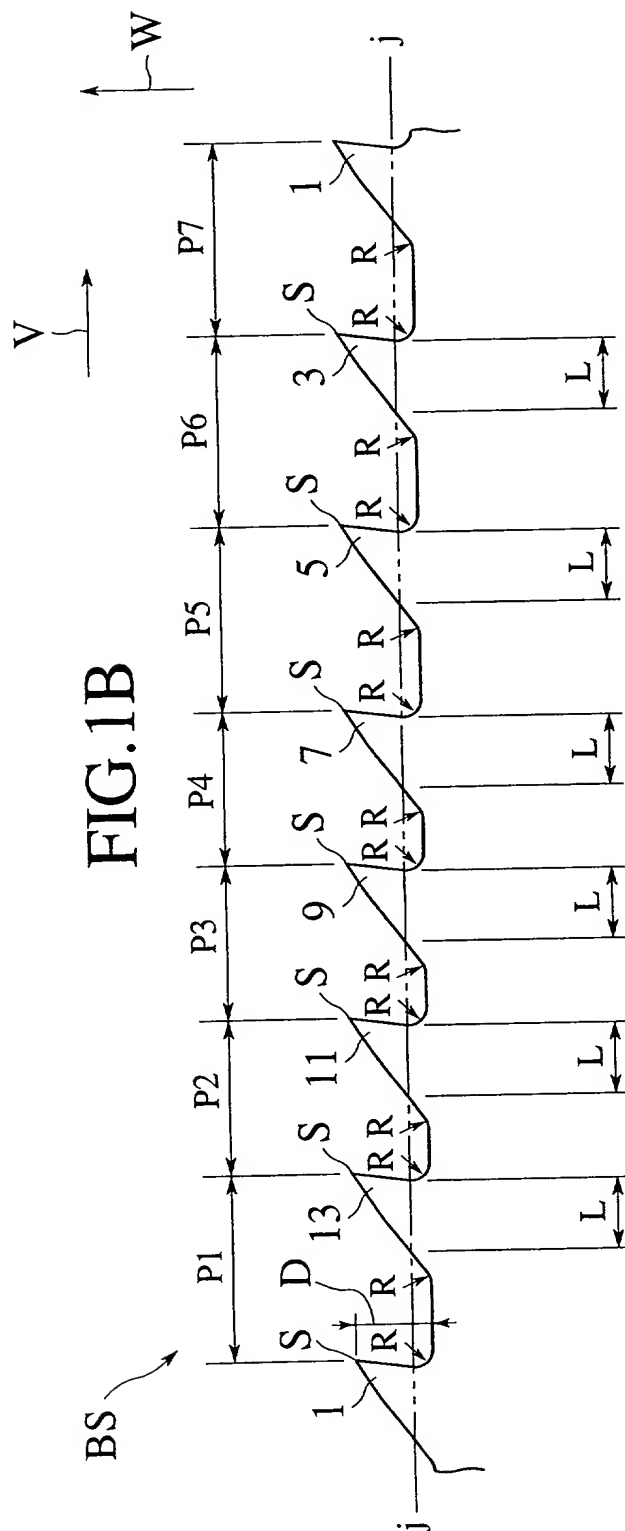
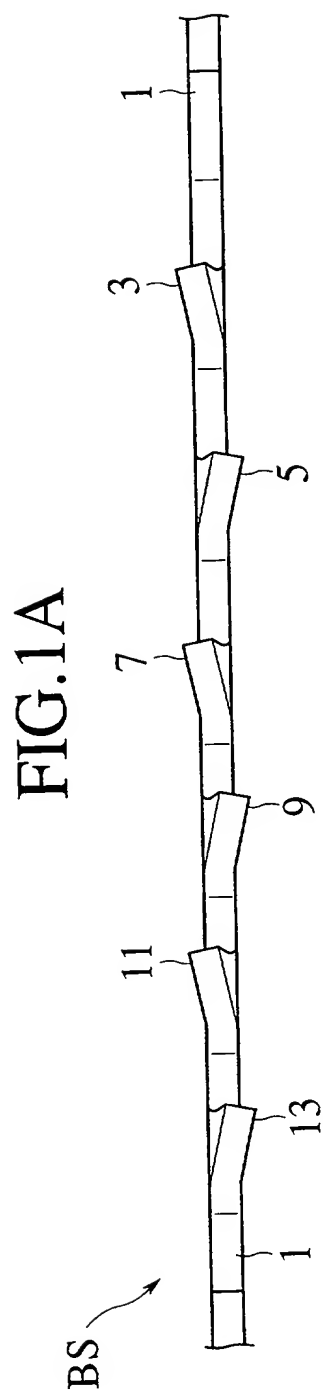


FIG.2A

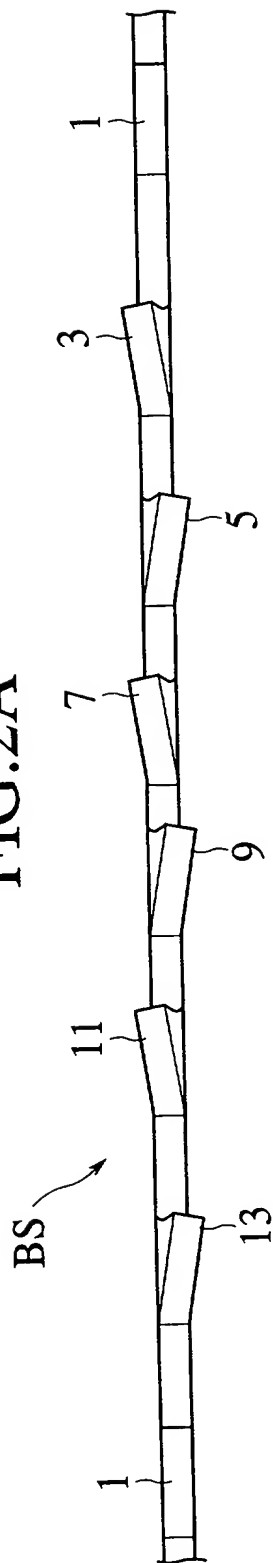


FIG.2B

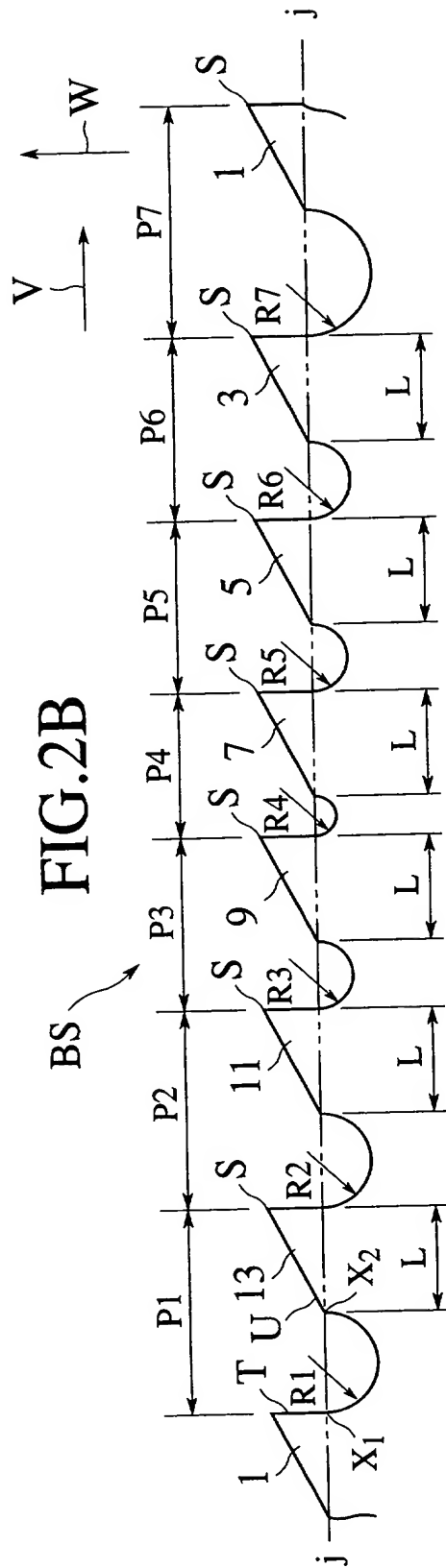


FIG.3A

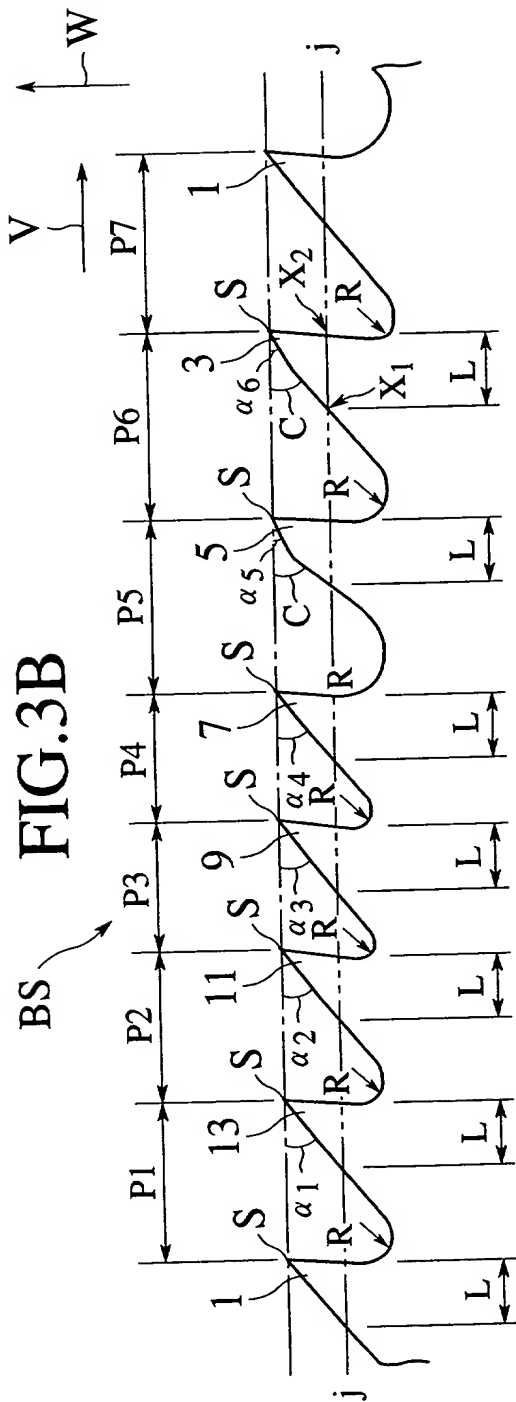
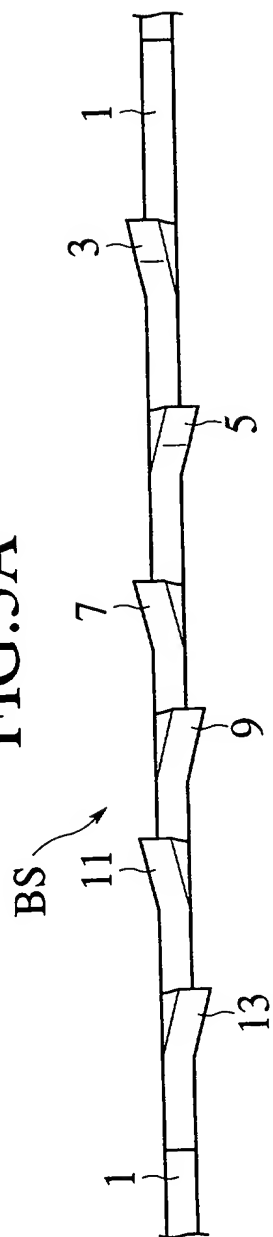




FIG. 5A

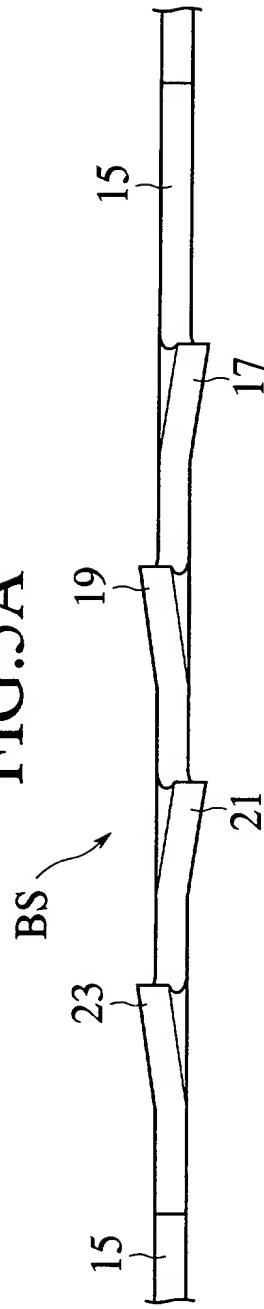


FIG. 5B

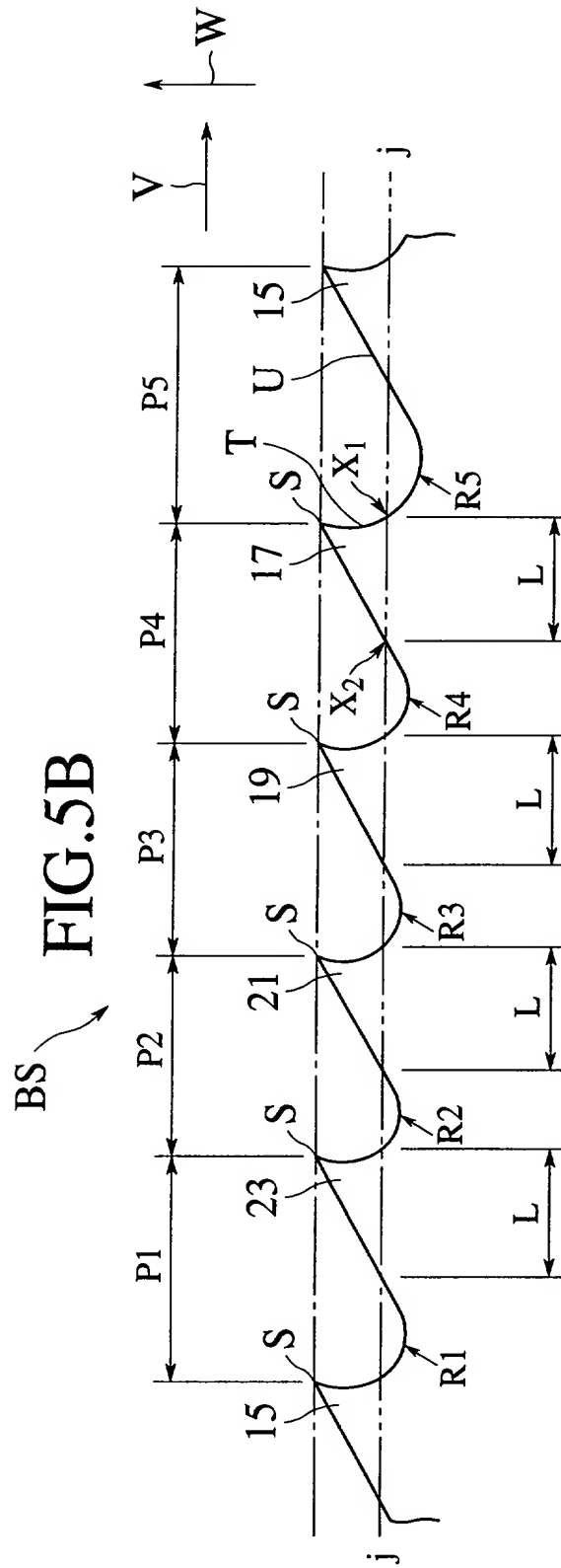


FIG.6A

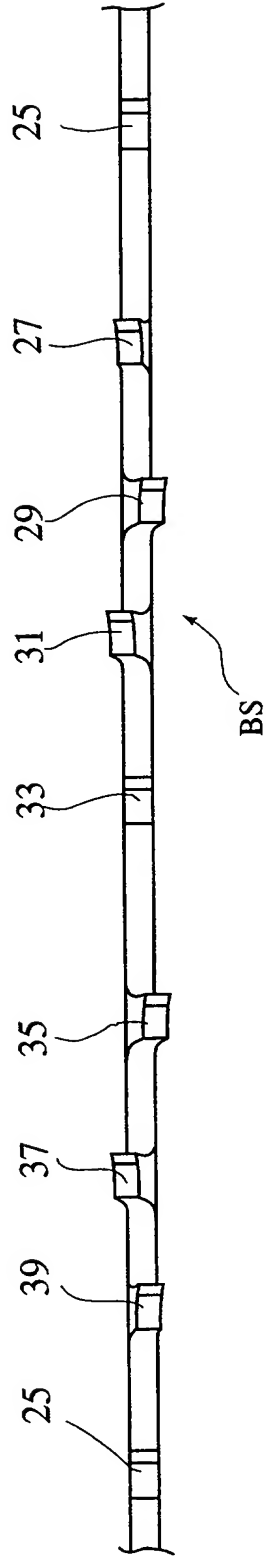


FIG.6B

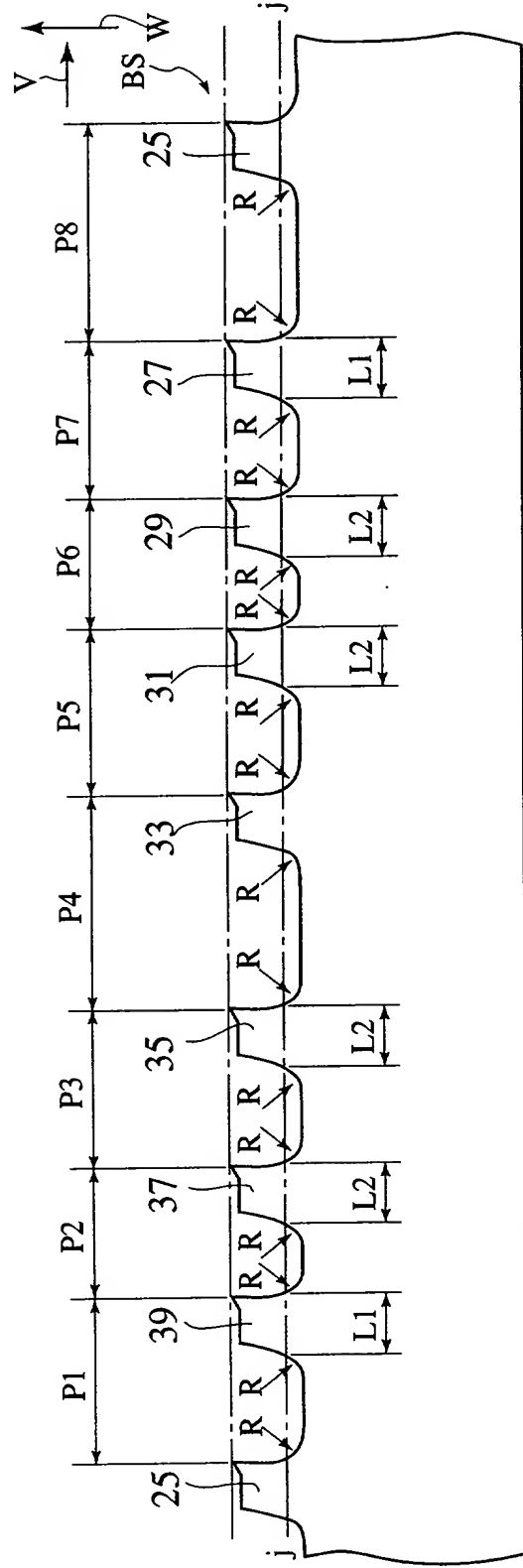


FIG.7A

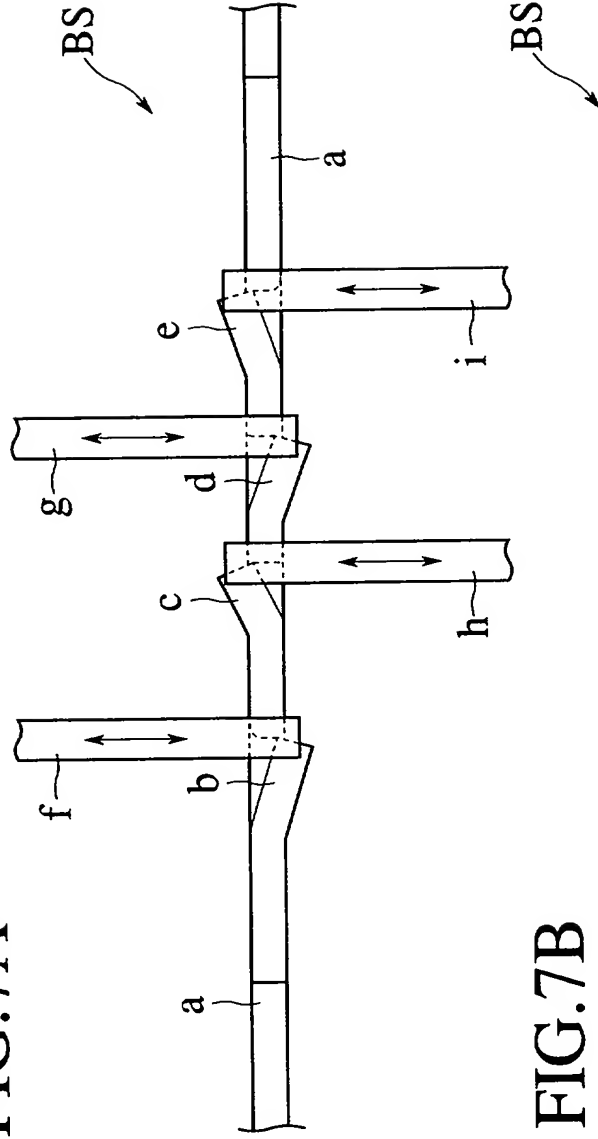


FIG.7B

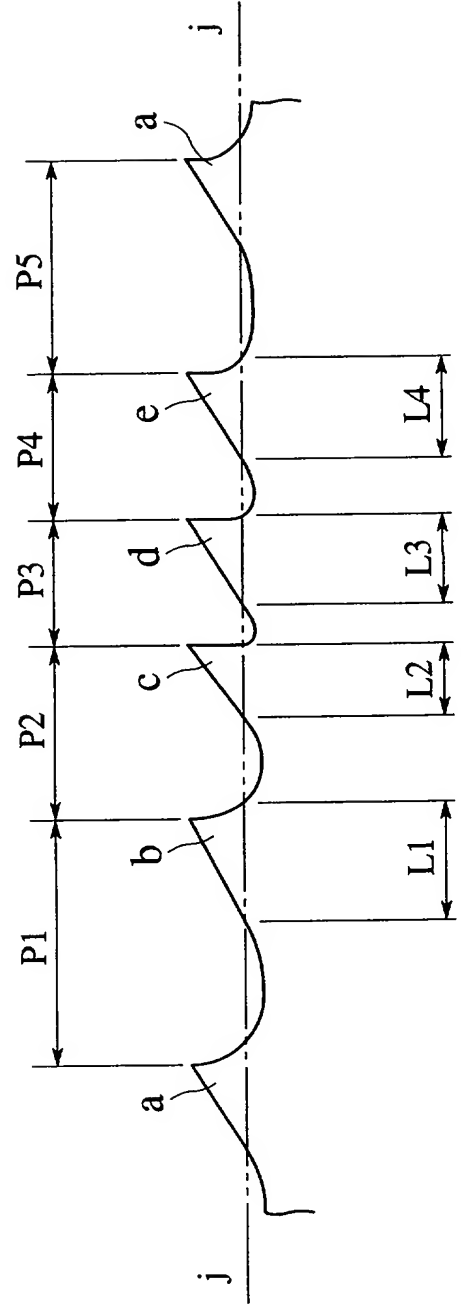


FIG.8A

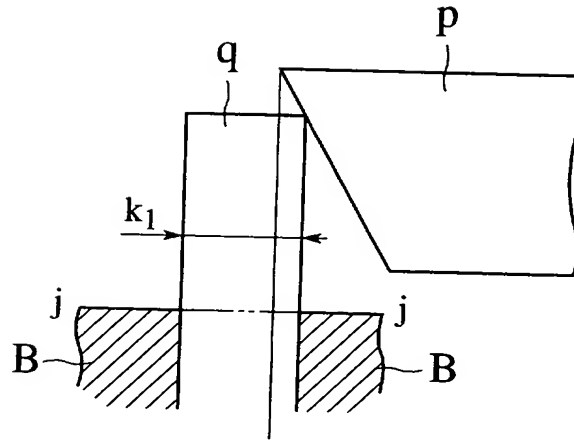


FIG.8B

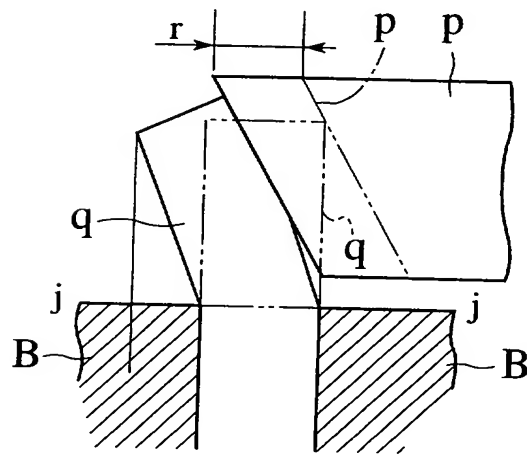
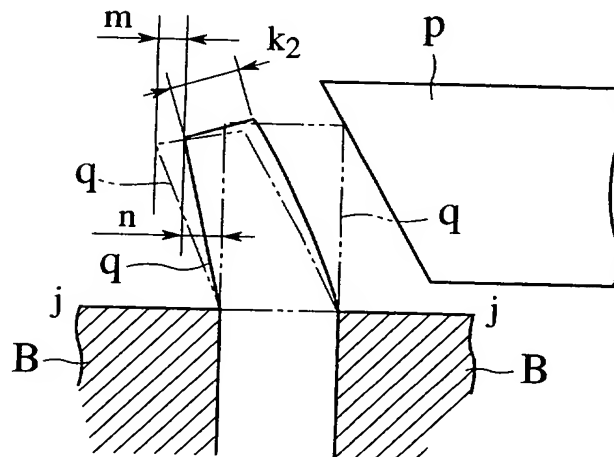


FIG.8C



DECLARATION FOR PATENT APPLICATION

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

BAND SAW BLADE

the specification of which is attached hereto unless the following box is checked:

☐ was filed on _____ as United States Application Number or PCT International Application Number _____ and was amended on _____ (if applicable).

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR §1.56.

I hereby claim foreign priority benefits under 35 U.S.C. §119(a)-(d) or § 365(b) of any foreign application(s) for patent or inventor's certificate, or §365(a) of any PCT International application which designated at least one country other than the United States, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate, or PCT International application having a filing date before that of the application on which priority is claimed.

PRIOR FOREIGN/PCT APPLICATION(S) AND ANY PRIORITY CLAIMS UNDER 35 USC §119			
APPLICATION NUMBER	COUNTRY	(DAY/MONTH/YEAR FILED)	PRIORITY NOT CLAIMED
JP 09-118311	JAPAN	08/05/1997	

I hereby claim the benefit under 35 U.S.C. §119(e) of any United States provisional application(s) listed below.

PROVISIONAL APPLICATION(S) UNDER 35 U.S.C. §119(e)	
APPLICATION NUMBER	FILING DATE

I hereby claim the benefit under 35 U.S.C. §120 of any United States application, or §365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. §112.

I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR §1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application.

PRIOR U.S./PCT INTERNATIONAL APPLICATION(S) DESIGNATED FOR BENEFIT UNDER 37 U.S.C. §120		
APPLICATION NUMBER	FILING DATE	STATUS -- PATENTED, PENDING, ABANDONED

I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and to transact all business in the Patent and Trademark Office connected herewith: Herbert Cohen, Reg. No. 25,109; Victor M. Wigman, Reg. No. 25,201, George C. Myers, Jr., 27,040; Saul Leitner, Reg. No. 22,283; Michael C. Greenbaum, Reg. No. 28,419; Michael D. White, Reg. No. 32,795; Joseph G. Seeber, Reg. No. 27,719; and Karl O. Neidert, Reg. No. 39,313.

Address all correspondence to:	WIGMAN, COHEN, LEITNER & MYERS, P.C. The Farragut Building, 10th Floor 900 17th Street, N.W., Suite 1000 Washington, D.C. 20006	Address all telephone calls to: (202) 463-7700 (202) 463-6915 (Fax)
--------------------------------	--	---

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Full name of sole or first inventor (given name, family name):		Susumu TSUJIMOTO
Inventor's signature:	<i>S. Tsujimoto</i>	Date: April 17, 1998
Residence:	HYOGO, JAPAN	Citizenship: JAPAN
Post Office Address: 80-293, Tenjin-cho, Ono-shi, HYOGO, JAPAN		
Full name of second joint inventor (given name, family name):		
Inventor's signature:		Date:
Residence:		Citizenship:
Post Office Address:		
Full name of third joint inventor (given name, family name):		
Inventor's signature:		Date:
Residence:		Citizenship:
Post Office Address:		
Full name of fourth joint inventor (given name, family name):		
Inventor's signature:		Date:
Residence:		Citizenship:
Post Office Address:		